

Shp 27/06

Work Order ID 70917

Friday, June 17, 2011 8:26:58 AM



Page 1

Item ID: D3180-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Assembly

Start Date: 6/17/2011 Start Qty: ~~2.00~~ 3



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3180

Rev B

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch Tubing to length as per Dwg D3180 using DT8313
Ensure rotate and punch one end only as per view B-B as per Dwg. D3180
92.812

SB 11/06/20 (3)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill Ø0.203" as per Dwg D3180 2-Bend one side only as per Dwg
D3180 Identify as D3180-1 3-Deburr edges

SB 11/06/20

(2)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/06/20






(+3)



Work Order ID 70917




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Item ID: D3180-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Strut Assembly
Start Date: 6/17/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 6/17/2011 Req'd Qty: 2.00  Customer:

Reference:
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M116964.</i> Memo START TIME: <i>1:05</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>1:35.</i>	0.00 0.00				<i>3</i>	<i>0</i>	<i>PL 11-6-20.</i>	
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>3</i>	<i>0 Malo 1/20</i>
150  Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D3180	0.00 0.00						<i>3</i>	<i>3</i>

3 0 Malo 1/20
3 0 Malo 1/20

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Item ID: D3180-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut Assembly

Start Date: 6/17/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 6/17/11

(x3)

170

Identify as per dwg & Stock Location: 271

0.00



Packaging

Memo

0.00

Packaging

11/6/21

32SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/21
me
11-06-21

Picklist Print

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Page 1

Work Order ID: 70917

Parent Item: D3180-041

Parent Item Name: Strut Assembly



Start Date: 6/17/2011

Required Date: 6/17/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 03.01.27 New issue KJ/RF
IPP Rev:B 07-06-28 Asper Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
A1449 Grommet		Purchased	No			150	Each	1,183.000	1	2		6/11/06/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST281		1183							
					1487	1183							
AN960JD10 Washer	NAS1149D0363J	Purchased	No			150	Each	0.0000	3	6		6/11/06/21	
				4 M117291									
BLRS-001 Pip Pin		Purchased	No			150	Each	6.0000	1	2		6/11/06/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST283		6							
					113002	6							
D2022-101 Spacer		Manufactured	No			150	Each	110.0000	2	4		6/11/06/21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		110							
					69532	50							
					69824	60							

Picklist Print

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Work Order ID: 70917

Parent Item: D3180-041

Parent Item Name: Strut Assembly

Start Date: 6/17/2011

Required Date: 6/17/2011

Start Qty: 2.00

Required Qty: 2.00

D2690-6 Manufactured No

150 Each

10.0000

1

2



Lanyard Assembly

Location

Loc Qty

Loc Code

ST020

10

66873

1

70512

9

M304TR0.750W.065

Purchased

No

150

f

40.5000

3.5833

7.543789



304 RD Tube .750 x .065W

Location

Loc Qty

Loc Code

MAT017

40.5

114002

40.5

M 114812

150

Each

2,139.000

1

2

MS21042L3

Purchased

No



Nut

Location

Loc Qty

Loc Code

ST300

2139

116391

9

116549

430

117441

800

117601

400

117885

500

MS27039-1-10

Purchased

No

100
150

Each

205.0000

1

2



Screw

Location

Loc Qty

Loc Code

ST290

150

117441

150

ST291

55

115935

55

Ep 5/11/06/21
B70920 (2x)

JB 11/6/20

94
Ep 5/11/06/21

23

Ep 5/11/06/21

23

Friday, June 17, 2011 8:26:55 AM

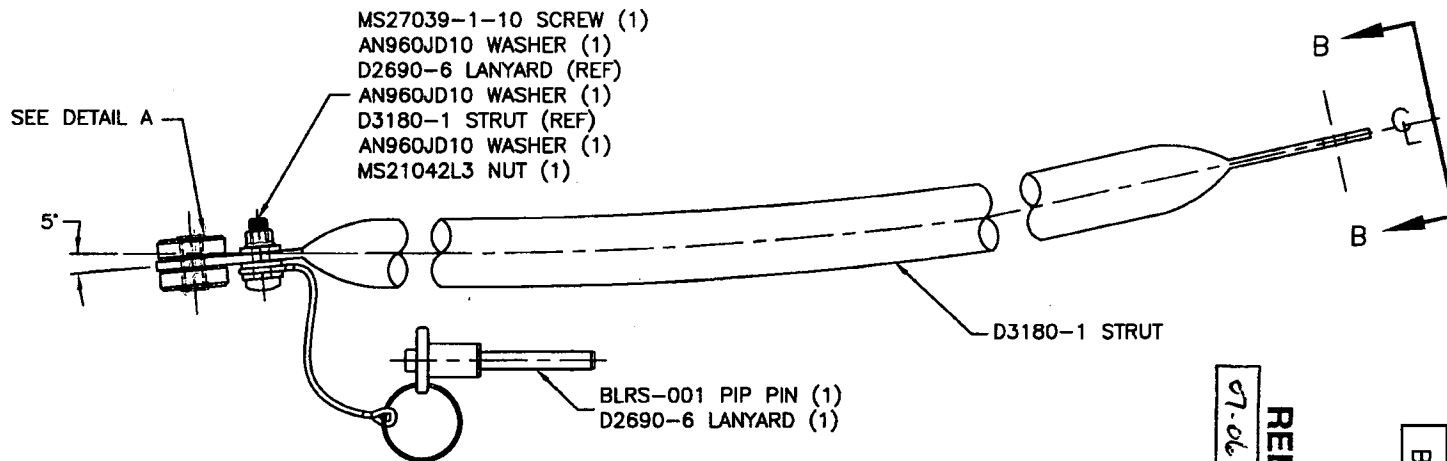
Shop Packet Print

Page 2



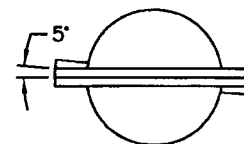
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. B
#	JL	DRAWING NO.	D3180	SHEET 1 OF 2	SCALE
CHECKED CE	APPROVED #	DATE	07.05.23	TITLE	STRUT ASSEMBLY
A	03.01.06	NEW ISSUE			
B	07.05.23	CURVE ADDED			

RELEASED
07.06.08



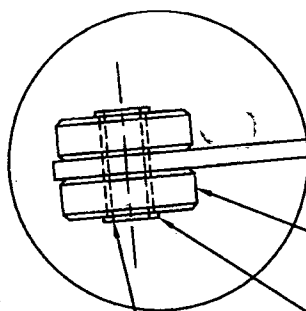
D3180-041 STRUT ASSEMBLY

W070917



VIEW B-B
SCALE 1:1

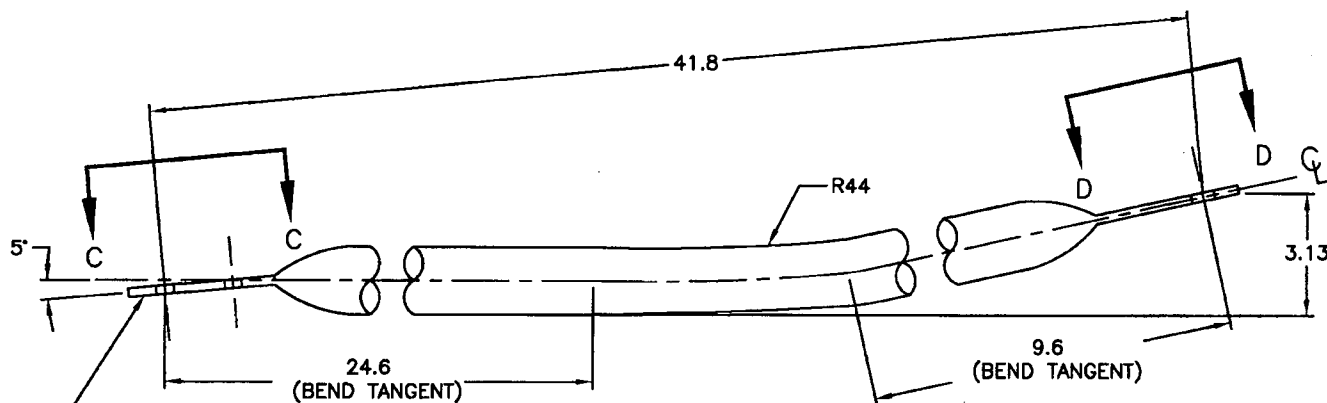
QTY	PART NUMBER	DESCRIPTION
-041		
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET



DETAIL A
SCALE 1:1

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
07.05.23	D3180	SHEET 2 OF 2
	TITLE	SCALE
	STRUT ASSEMBLY	1:2



D3180-1 STRUT

USE PUNCH DT8117
BOTH ENDS
(DIMS PER SPEC. CONTROL DWG D2638)

RELEASED
07.06.28

70917

NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
Ø0.75 X 0.065 WALL
(REF. DART SPEC M304TR0.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERMANENT INK MARKER

